

44

DART AEROSPACE LTD		Work Order:	21735
Description: Float Web		Part Number:	D3282-041
04.10.18 (4.10.18CP)			
Dwg: D3282 Rev. A1		Qty:	20
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	(H)	04.10.18	20
2	LG	Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 1 D2600-7-125 Web _____ 2 D3283-1 Doubler _____ 80 MS20470AD4-7 Rivet _____			
3	LG	Cut D2600-7-125 to 125.000" as per Dwg D3282			
4	LG	Transfer drill web from D3283-1 doublers			
5	LG	Drill web using DT8734 as per Dwg D3282			
6	LG	Using uni-bit, open holes as per Dwg D3282			
7	LG	Deburr holes and ends			
8	FP	Chemical Conversion Coat as per QSI 005 4.1			
9	LG	Rivet doublers as per Dwg D3282			
10	QC5	Inspect work to Step 9			
11	LG	Identify and Stock			
12	AC	Cost / part: <u>0</u>		548 05.03.03	
13	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	04.09.28	New Issue	KJ/JLM	<i>[Signature]</i>

RELEASED
04.09.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries

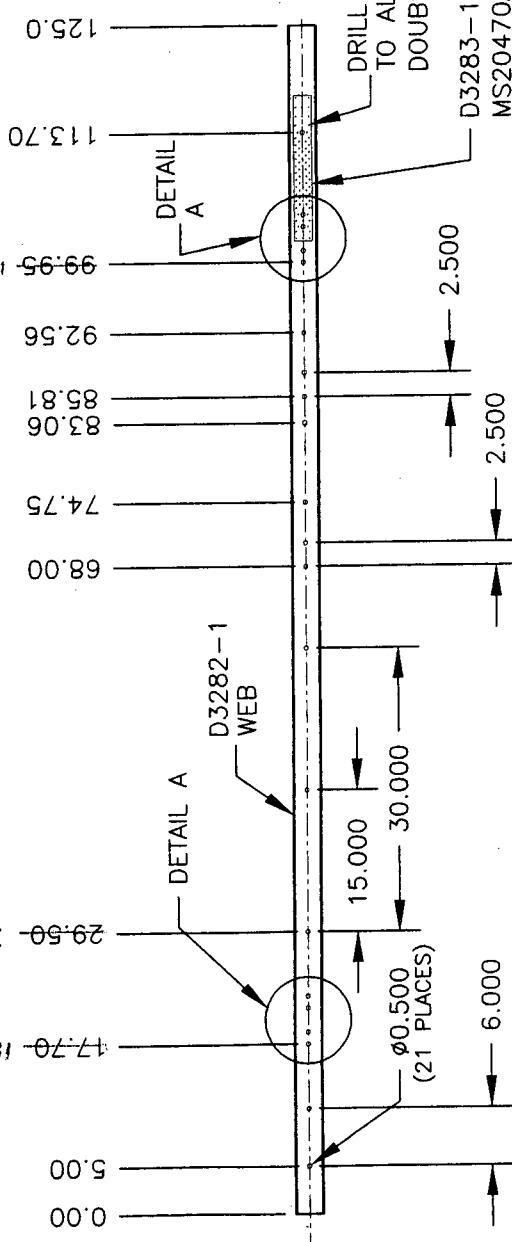
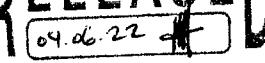
QA: N/C Closed: _____ Date: _____

DARTCOPY IS
MADE
HERE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
		D3282	REV. A
DATE		TITLE	SCALE
04.05.05		FLOAT WEB, 206L/407	1:20
A	04.05.05	NEW ISSUE	
A1	04.08.13	MOVE HOLES	

RELEASED

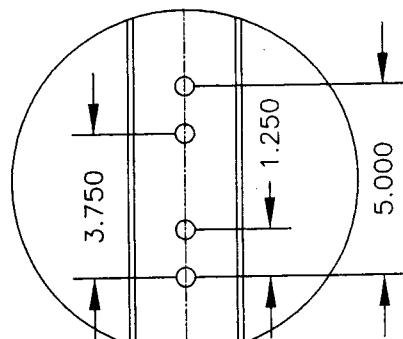
04.06.22



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. Z1735

DETAIL A
SCALE 1:5
RIVET HOLES NOT SHOWN

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Job Costing Report

Dart Aerospace Ltd.
HawkesburyOct 18, 2004
12:35 pm

Work Order No : 0021735
 Project Name : D3282-041
 Project For : WK444
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3282-041
 Description : I-Beam
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 10-18-04
 Est Finish Date : 10-30-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00